

Deriv. Sec 680

Work Order ID 51398

August 21, 2009 9:00:48 AM



Page 1

Item ID: D3372-7

Accept



Setup Start



Revision ID: B

Item Name: Slider Body

Stop



Start Date: 24/08/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 04/09/2009 Req'd Qty: 6.00

Customer:

Reference:

09-08-21

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev. Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3372

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 1.500" x 1.250" x 4.435" long

SL 09/08/24

6 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3372-7 as per Folio FA495 and Dwg D3372 Identify as D3372-7 Debur

aml 09/08/26

6 2

PTD

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

aml 09/08/26

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3372-7 PAR #: _____ Fault Category: Machining NCR: (Yes) No DQA: _____ Date: 10-03-16
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 10/03/16

NCR: <u>51398</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>04/08/26</u>	<u>110</u>	<u>Part scrap. the thread strip, the tap was full of chips. A chip jammed in the tap causing chip build-up. R.C.'s process.</u>	<u>[Signature]</u> <u>05/08/26</u>	<u>scrap and destroy replace Qty: 2 B 110936</u>	<u>[Signature]</u> <u>09/08/26</u>	<u>[Signature]</u> <u>09/08/27</u>	<u>[Signature]</u> <u>05/08/26</u>	<u>[Signature]</u> <u>05-08-26</u>

NOTE: Date & initial all entries

Work Order ID 51398

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



8.568/08/27

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



MD 09/08/27

HandFinish

Memo

0.00

Hand Finishing

(X6)

150

QC3- Inspect Part Finish

0.00



24 09/08/27

QC

Memo

0.00

Quality Control

(X6)

Work Order ID 51398

August 21, 2009 9:00:48 AM



Page 3

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Accept



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Item Name: Slider Body

Start Date: 24/08/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 04/09/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160



Small Fab

Small Fab

0.00

ml 10/02/14

6 8

Memo

0.00

Small Fab

Fabricate D3372-9 using AN6-36A bolt. ☐ Cut to length, then mill slot when bolt and D3372-7 are assembled as per Dwg D3372.

170



QC

QC5- Inspect part completeness to step on W/O

0.00

8.10/02/14

(76)

Memo

0.00

Quality Control

180



Powdercoat

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00

M1102391

JL 10/02/24

(26)

7

Memo

0.00

Powder Coating

START TIME: 2:45pm ☐ OVEN TEMPERATURE:
3:15pm ☐ FINISH TIME: 3:20°F

Work Order ID 51398

August 21, 2009 9:00:48 AM



Page 4

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Accept



Setup Start



Revision ID: B

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Item Name: Slider Body

Start Date: 24/08/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 04/09/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

= 7 m-h 10/02/25 (6x)

200

Identify as per dwg & Stock Location: 480

0.00



Packaging

Memo

0.00

Packaging

P 14/3/01 (6)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/02

MF 10-3-01

Picklist Print

August 21, 2009 9:00:47 AM

Work Order ID: 51398

Parent Item: D3372-7RevB

Parent Item Name: Slider Body



Comments:

Start Date: 24/08/2009

Required Date: 04/09/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6-36A 		Purchased	No			110	Each	149.0000	6.0000			
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	149	
109632	1	
110382	2	
111650	46	
112314	100	

M6061T6B1.500X01.25
0

Purchased

No

160

f

71.3200

2.4208



6061-T6 Bar 1.50 x 1.25

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	71.32	
107461	11.84	
110936	59.48	

6 *mk 10/02/14*

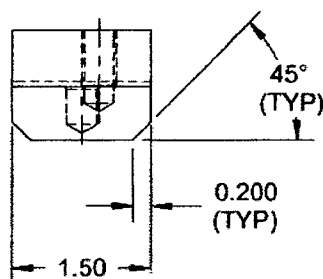
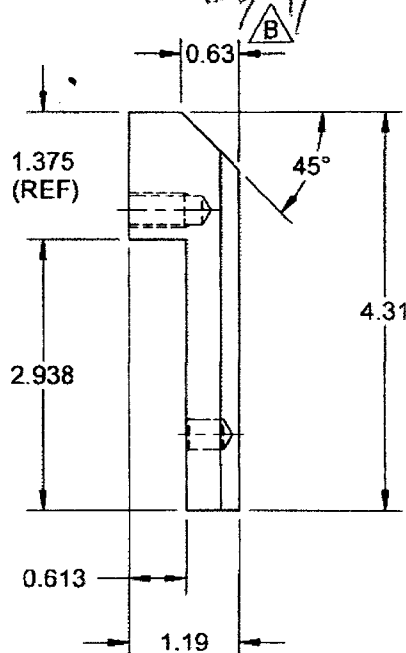
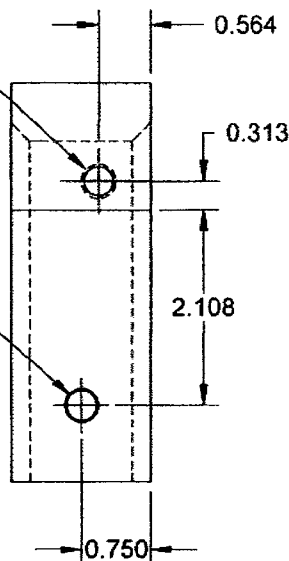
1.370 *SL 09/08/24*



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 7 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

DRILL $\varnothing 0.332$
("Q" DRILL) x 0.881 DEEP,
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL $\varnothing 0.323$
("P" DRILL) x 0.500 DEEP
CHAMFER 0.030 x 30°



RELEASED
[Signature]
25/04/28

W/O 5139B

D3372-7 SLIDER BODY

NOTES:

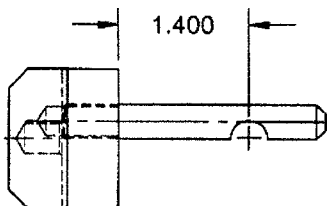
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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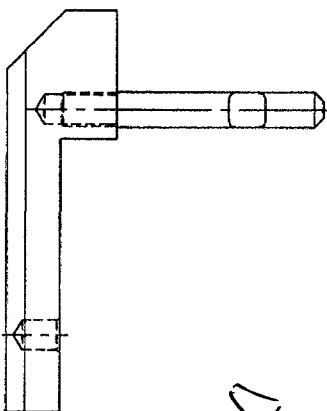
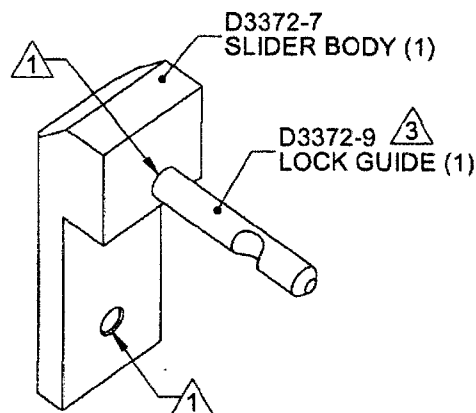
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



RELEASED
[Signature]
05/04/23



51398

D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

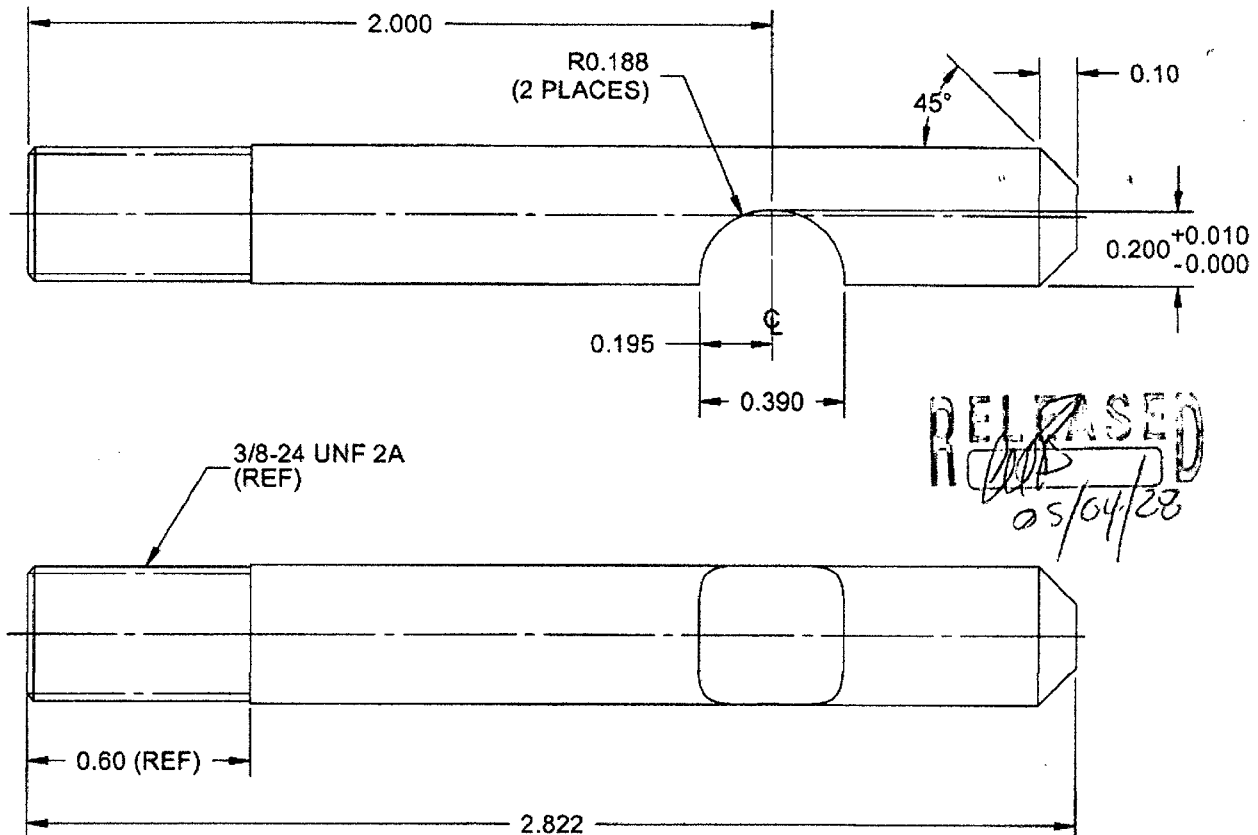
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 8 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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